

304 R.500 X-035W

X Re-Print/Duplicate X 1

Work Order ID 77496

77496

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Wednesday, February 01, 2012 10:57:49 AM

Item ID: D3591-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bushing

Start Date: 12/8/2011 Start Qty: 20.00

20

Cust Item ID:

Required Date: 12/16/2011 Req'd Qty: 20.00

20

Customer:

Reference:

Jan 12 02 01

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3591

Rev B

100

0.00

100

CONVENTIONAL LATHE

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-Turn as per dwg D35912-Deburr

OK 12/02/09

20

X

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

OK 12/02/09

20

X

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

SL 12-02-10

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Item ID: D3591-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bushing
 Start Date: 12/8/2011 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 12/16/2011 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location. STFP	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

201 **SP 12-02-10**
M.L.S 12/02/15

M.L.S 12/02/15
20

Picklist Print

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Page 1

Work Order ID: 77496

Parent Item: D3591-1

Start Date: 12/8/2011

Required Date: 12/16/2011

Parent Item Name: Bushing

Start Qty: 20.00

Required Qty: 20.00

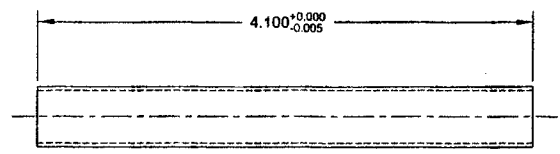
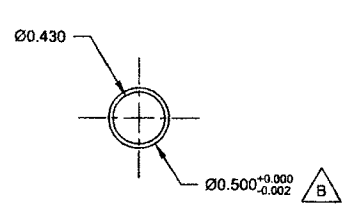
Comments: IPP A 07.02.01 new issue EC
IPP Rev:B 08-09-10 revB as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.035 304 RD Tube .500 x .035W		Purchased	No			100	f	86.2383	0.35	7.3684211			

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT017	86.2382723	
115535	0.913	
116720	1.66068	
117598	7.6415923	
119160	12.09	
119644	63.933	

M120633 x 8' on 12/02/09

937tt



D3591-1 BUSHING

RELEASED
08-09-03/11

- NOTES:**
- 1) MATERIAL: AISI 304/316 SS, Ø0.500, 0.035 WALL SEAMLESS ROUND TUBING
REF. DART SPEC M304TRO.500W.035
OR: AISI 303/304/316 SS, ROUND BAR
REF DART SPEC M303R/M304R
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: N/A

B	DRAWING UPDATED TO "B" SIZE FORMAT AND CURRENT STANDARDS. ZN C6 TOLERANCE WAS -0.005. MATERIAL UPDATED TO ALLOW PART TO BE MACHINED TO MAINTAIN TOLERANCE. (SEE NCR 08-074 FOR FURTHER DETAILS.)		AJS	08.08.25
A	NEW ISSUE		PH	07.01.16
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D3591	SHEET 1 OF 1	
APPROVED		TITLE	SCALE	
DE APPR.		BUSHING	NTS	
DATE	08.08.25		<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, BE COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	